

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020839**Date Inspected:** 21-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr.Liu Huajie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

SEGMENT # 9W:

Shielded Metal Arc Welding (SMAW) welding of weld joint DP684-001-018.Welder is identified as 069683.

ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-T-4114-B-1.

SMAW welding of welds joint SP730-001-048, Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS:

WPS-B-T-2233-B-U2-FCM.

SMAW welding of welds joint CA059-005, CA061-001(SP-EP), Welder is identified as 068097. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW welding of welds joint SEG051-044, CA062-006(EP-DP, CB SIDE), and Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of welds joint CA059-006, CA061-002(EP-DP, CW SIDE), and Welder is identified as 068097. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

SEGMENT#9E

During surveillance Inspection we found 9AE+9BE Panel points 73 holes drilling activity was in progress And Snug Tightening was in progress at panel points PP74.

Flux Cored Arc Welding (FCAW) welding of Buildup for welds joint LD18C, And Welding Repair Report (WR) B-WR14077, and Welder is identified as 051246; ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-345-FCAW-1G (1F)-REPAIR-1.

Shielded Metal Arc Welding (SMAW) welding of welds joint SEG054C-001, SEG054B-024(9CE+9DE). Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-T-2232-TC-U4b-FCM, /WPS-B-T-2233-TC-U4b-FCM.

SMAW welding of weld joint SEG052A-045, SEG054A-014(9BE-9CE), And Critical Welding Repair Report (CWR) B-CWR-1679-1, Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy
----------------------	--------------------

Quality Assurance Inspector

Reviewed By:	Miller,Mark
---------------------	-------------

QA Reviewer
